

Work Order ID 164298

Monday, July 17, 2017 9:22:20 AM

164298

Page 1

Item ID: D4941-1L08 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Fwd LH, (Clear)
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: **JUL 17 2017** Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4941	D

110

0.00

110

THERMOFORMING MACHINE

Purchasing

Memo

0.00

Purchasing

ISSUE P/O: 37108
SUPPLIER: PLASTECH

MANUFACTURE D4941-1L08 AS PER DWG

C OF C IS REQUIRED

4 JUL 19 2017 DAS 13 9-89

140

0.00

140Receive & Inspect for Damage & Mat'l Certs
HAND FINISHING THERMOFORMING

Packaging

Memo

0.00

Packaging

4x 8017-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 164298

Monday, July 17, 2017 9:22:20 AM

164298

Page 2

Item ID: D4941-1L08 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Fwd LH, (Clear)
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 57615	0.00							
170									
Packaging	Memo 57608A	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

4 **17.08.20** **PD**

✓ **SEP 20 2017** **DAS**

17/9/21 **98**

SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 17, 2017 9:22:23 AM

Page 1

Work Order ID: 164298

164298

Parent Item: D4941-1L08

D4941-1L08

Parent Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL
DL
Verify DD

IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev D Revised Dwg. 14/07/25
IPP Rev.E 17.06.13 Now outside process DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-1L08P		Purchased	No			110	Each	0.0000	1	4			
D4941-1L08P									**				
Floor Protector, Fwd LH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	19.5			
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				RM	194.56897								
				m126994	194.56897								

4x spt 7-9-12.

SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

DART AEROSPACE LTD		Work Order: 164248
Description: Floor Protector, LH Fwd		Part Number: D4941-1L02/L08
Inspection Dwg: D4941	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07 9-89	Date: 17/09/13
---------------------------------------	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0	+/-0.100	2.05"	✓			
0.8	+/-0.100	0.88"	✓			
0.4	+/-0.100	0.46"	✓			
6.9 N/A	+/-0.100					
13.5	+/-0.100	13.45"	✓			
7.2 N/A	+/-0.100					
20.1	+/-0.100	20.1"	✓			
20.9	+/-0.100	20.9"	✓			
0.070	Min	0.089"	✓			
0.030	Min	0.043"	✓			
1.5"	Y-0.100	1.4"	✓			
7.2"	+/-0.100	7.2"	✓			

Measured by: DAS 07 9-89	Date: 17/09/14
Audited by: PD	Date: 17.09.20
Preliminary Approval:	Date:

Rev	Date	Change	Revised By	Approved
A	15.04.27	New Issue	KJ	

DQA: _____ Date: _____

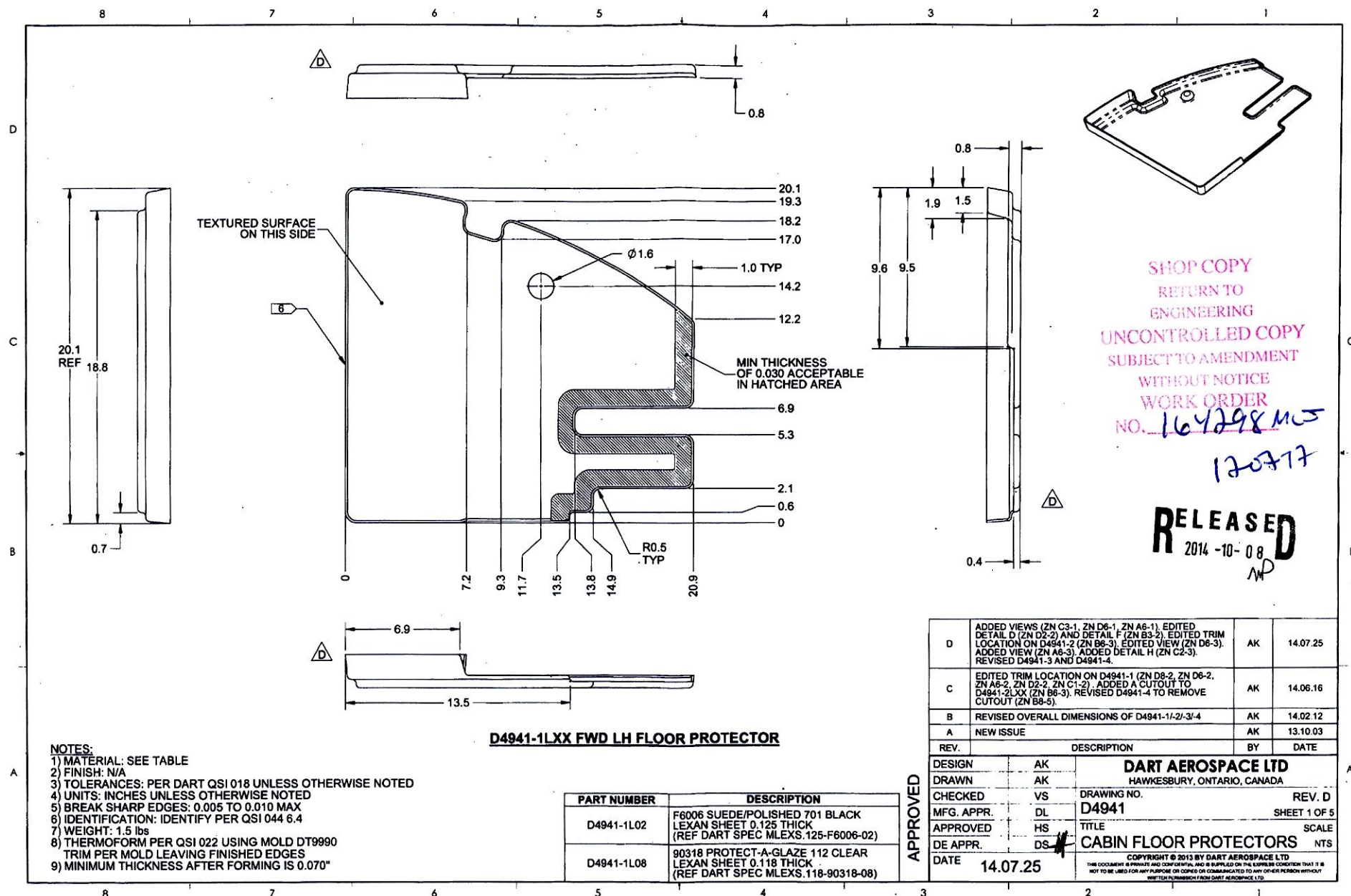


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

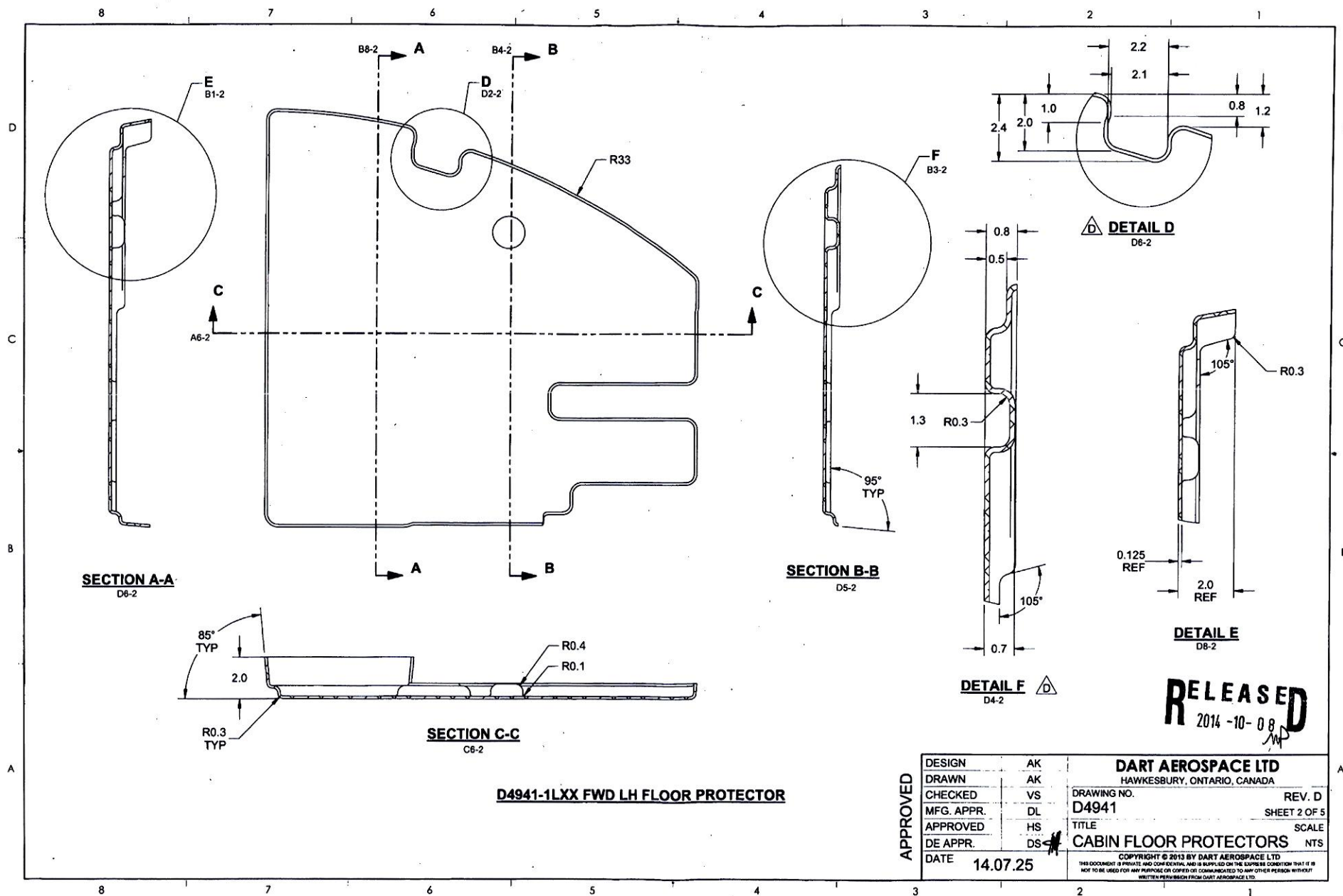
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164298 MC

RELEASE
2014-10-08

D	ADDED VIEWS (ZN C2-1, ZN D6-1, ZN A6-1) EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2). EDITED TRIM LOCATION ON D4941-2 (ZN B6-3). EDITED VIEW (ZN D6-3). ADDED VIEW (ZN A6-3). DETAIL H (ZN C2-3). REVISED D4941-3 AND D4941-4.	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D8-2, ZN D6-2, ZN A6-2, ZN D2-2, ZN C7). ADDED A CUTOUIT TO D4941-2-2LX (ZN B6-3). REVISED D4941-4 TO REMOVE CUTOUIT (ZN B8-5).	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-1/2-3/4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4941 SHEET 1 OF 1 TITLE CABIN FLOOR PROTECTORS NT COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMBARGATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS		
DATE	14.07.25		





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 7 of 9

Order From :

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$300.00

19 D4635-4P

Aft Ceiling Panel, RH

7/31/2017

Yes

7/31/2017

3.00

Each

\$100.00

\$300.00

MANUFACTURE AS PER DWG D4635 REV. F
B164295

Line Total: \$300.00

20 D4888-1L02P

Dome Light Housing, Black

7/31/2017

No

7/31/2017

4.00

Each

\$100.00

\$400.00

MANUFACTURE AS PER DWG D4888 REV. A
B164296

Line Total: \$400.00

21 D4941-1L08P

Floor Protector, Fwd LH,
(Clear)

7/31/2017

Yes

7/31/2017

4.00

Each

\$100.00

\$400.00

MANUFACTURE AS PER DWG D4941 REV. D
B164298

Note:

7/19/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24293
Shipment Date: 08/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37108
Carrier Account #

Sales Order
SO-019288

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number

Ship Via
FREIGHTCOM INC. -

Item Number - Revision Description

D4941-1L08 - Rev.: D CABIN FLOOR PROTECTORS
P. 2923 HS Code: 3920.61.1000 - OTHER Country of Origin : CA
D4941-2L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA
D4941-3L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA
D4941-4L08 - Rev.: D CABIN FLOOR PROTECTORS
HS Code: 3920.61.1000 - OTHER Country of Origin : CA

Quantity UOM
Shipped

4 EA

4 EA

4 EA

4 EA

SP17-9-12

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	<u>D4941-1L08</u>	Qty.	<u>4</u>	Batch #	<u>-021</u>
Description	<u>CABIN FLOOR PROTECTORS 1SHEET M138294</u>				
Part #	<u>D4941-2L08</u>	Qty.	<u>4</u>	Batch #	<u>-022</u>
Description	<u>CABIN FLOOR PROTECTORS 1SHEET M138294</u>				
Part #	<u>D4941-3L08</u>	Qty.	<u>4</u>	Batch #	<u>-023</u>
Description	<u>CABIN FLOOR PROTECTORS 1SHEET M138294</u>				
Part #	<u>D4941-4L08</u>	Qty.	<u>4</u>	Batch #	<u>-024</u>
Description	<u>CABIN FLOOR PROTECTORS 1SHEET M138294</u>				
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 C OF C # 010
(Approved QA Signatory)

Page: 1 of 1

Inspection Checklist

COPY

PLAS-TECH
Think Plastics™

Customer: Dart Aerospace Ltd

SO # 019288-021

Description: Floor Protector, LH Fwd

Part #: D4941-1L02/L08

Inspection Dwg: D4941

Rev: D

Page: 1 of 1

Inspection Checklist:

☐

First Article

☐

Prototype

☒

First Off

Thermoforming Section

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratches	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Trimming Section

Drawing Dim.	Tolerance	Actual Dimensions	Accept	Reject	Method of Inspection	Comments
2.0	+/- 0.100	<u>N/A</u>				
0.8	+/- 0.100	<u>0.90</u>	✓			
0.4	+/- 0.100	<u>0.40</u>	✓			
6.9	+/- 0.100	<u>6.81</u>	✓			
13.5	+/- 0.100	<u>13.56</u>	✓			
7.2	+/- 0.100	<u>7.18</u>	✓			
20.1	+/- 0.100	<u>20.1</u>	✓			
20.9	+/- 0.100	<u>20.89</u>	✓			
0.070	Min	<u>N/A</u>				
0.030	Min	<u>0.036</u>	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Approval by: _____

Date: _____

Rev.	Date	Change	Revised by	Approved